Work Order ID 100271 April-22-13 12:52:25 PM				,,,,,	Page 1										
Item ID: D4003-1 Revision ID:					Accept	*	*N900	<u>)</u> 040	100)*	Setup Star			S1 ²	
Item Name:	Fwd Fuel Gut	ter Line	15									Stop	*N	S2*	k
Start Date:	4/22/13	Start Qty:	4.00	*4*			Cust Item	ID:							
Required Date:	5/03/13	Req'd Qty	: 4.00	*4*			Customer	:							,
Reference:															
Approvals:	Process Pla	in: _ Mc 3	5	Date: 13-04-7	Y Tooling	:	I	Date:	4		Run	Start	*N	R 1 ³	*
	QC:				·		I				Stop	*NR2*		* ;	
Sequence ID/ Work Center II	Operation Description				Set U Run	Jp/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	-	Reject Number	Insp. Stamp	o
Draw Nbr	Rev	ision Nbr							<u>-</u>						
D4003	A		1					•							7 .
100					0.00									IJ,	
100 Small Fab		N	1emo		0.00					15x				J.)B [
Small Fab		1	- Cut tube	as per dwg											•
110		QC5- Inspect	part comp	leteness to step on W/O	0.00	301				is					,
110						9.6	i								
QC Quality Control	•	N	1emo		0.00	17 20	y'								1
									}						1
170		Identify as per	r dwg & S	tock Location:54083	0.00					_				ON.	
170 Packaging		N	Aemo		0.00					(13)	13-0	02-01		D	

Packaging

											DQA:	Da	ite:			
NCR: Ye	s / No				WORK ORDER NON-O	O	NFORM	MANCE / UP	DATE			,				
											QA Closed:	Da	te:			
Work Order: Part No. NCR No.					DISPOSITION		AGAINST DEPARTMENT/PROCESS									
					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other			
WCK NO					Work order opuate	ı		conge ras	composite_	_		Supplier	 i			
Root				Descri	iption of work order update	Π	nitial	Act	tion	Τ	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Cr	ief Eng	Desc	ription		Date	Verificatio	n ·	QC Inspector		
Doc/Data													-			
Equip/Tooling						1				1						
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Material			į							١						
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Other						l										
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Landing	Gear			_	General					_			_	•		
	Bending			L	Bend	L	Grain		_		Ovalized			Pressure/Forced		
	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardware			_['	Over/Under	tolerance	L	Temperature/Cure		
	Cracks ⁽				Broken/Damaged		Inspection Incomplete			_	Part Incorrect			Weld		
	Crushed/	Crimped			Burrs		instruct	ions Incomplete/	Unclear		Part Lost/Missing			Wrong Stock Pulled		
	Cuffs				Contamination	1	Maintenance				Part Moved					

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Work Ord		0271		*100				Page 2			
Item ID: Revision ID: Item Name:	D4003-13 Fwd Fuel Gut	tter Line		Accept	*N900	<u>040</u>	100	* s	Setup Sta Sto	1 7	S1* S2*
Start Date: Required Date Reference:	4/22/13 e: 5/03/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:						
Approvals:	Process Pla	an:	Date:	Tooling:	D:	ate:		I	Run Sta Sto	1/1	R1*
	QC:		Date:	SPC (Y/N):	Date:					*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		QC21- Final Inspection	- Work Order Release	0.00					12	ارارا)/\
180 QC Quality Control		Memo		0.00				· · · · · · · · · · · · · · · · · · ·	12	15/6	7

pl 13-05-1

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											DQA:	Date:		
NCR: Y	es /	No				WORK ORDER NON-CONFORMANCE / UPDATE								
												Date:		
Work Orde	r.					DISPOSITION AGAINS					PARTMENT	/PROCESS		
WOIK OIGE	'·					Rework	٦		Skid-tube Crosstube		1	Water Jet	Engineering	
Part N	0.					Scrap	\dashv	1	Machining Small Fab	_	Pro	d. Eng. Coor.	Quality	
	·-					Use-as-is	1	1	noforming Finishing	-	3	re/Packaging	Other	
NCR N	o.					Work Order Update	7		Large Fab Composite	_		Supplier		
			.											
Root						ption of work order update	4	Initial	Action		Sign &			
Cause	Da	ite	Step	Qty	,	or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector	
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Equip/Tooling		1												
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Material		.[
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							FAU	LT CATE	GORY					
Landir	ng Gear				_	General	_	٦			1	_	7- /-	
	Ben	-				Bend	<u> </u>	Grain		\vdash	Ovalized	⊢	Pressure/Forced	
	_		t Conce	entric to	o/s	BOM/Route	<u> </u>	Hardwa	··· -	-	Over/Under		Temperature/Cure	
	Crac				-	Broken/Damaged	-	_	ion Incomplete	-	Part Incorre		Weld	
			rimped	Ė		Burrs	\vdash	┪	tions Incomplete/Unclear	\vdash	Part Lost/M	issing	Wrong Stock Pulled	
	Cuff				<u> </u>	Contamination	<u> </u>	Mainte		\vdash	Part Moved			
		t Trea	1		<u> </u>	Countersink	\vdash	Mislabe		\vdash	Positioned \		704	
			Strip i	n Tube	<u> </u>	Cut Too Short	\vdash	Misread	d	L	Power Loss/	Surge	Other	
		les in	ł	_	<u> </u>	Drill Holes	<u> </u>	Offset	- 111 · · ·				· · · · · · · · · · · · · · · · · · ·	
	Torque Waves in Extrusion Drawing							Out of Calibration						
		_	equenc		_	Finish	<u> </u>	Out of Sequence						
	IWav	/e/Twi	ist in Tu	ıpe	l l	Folio	1	IOutside	Dimensions				1	

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-22-13 12:52:24 PM

Work Order ID:

100271

Parent Item:

D4003-13

Parent Item Name:

Fwd Fuel Gutter Line

Start Date: 4/22/13

Required Date: 5/03/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev A 10.01.12 new issue prelim EC verified by:DD DD verf:EC

IPP Rev:B 10.06.22 per dwg rev:A

	DD VCII.LC												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.035		Purchased	No			100	f	225.3472	0.125	0.5	13	/5	10,
6061-T6 RD Tube .375 x.0	035W								· · · · · · · · · · · · · · · · · · ·		f	ν,	
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT014		225.3472				روک	-		
				1126	52	117.3472			_/.	8 13			
				1244	91	108							

		- 1								DQA	.:Date	:		
NCR: Y	es / No				WORK ORDER NON-C	CONF	OA Classe	Doto						
		+			· · · · · · · · · · · · · · · · · · ·					QA Closed	: Date	;		
Marie Orda	<u>.</u>				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Ordei	r:	-			Rework	1 		Skid-tube	Crosstube	٦	Water Jet	Engineering		
Part N	0				Scrap	1		Machining	Small Fab	Pr	od. Eng. Coor.	Quality		
	··	:			Use-as-is	┪╽.		oforming	Finishing		ore/Packaging	Other		
NCR N	0.				Work Order Update	1		Large Fab	Composite]	Supplier			
												-		
Root					ption of work order update		Initial Action			Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector		
Doc/Data						1	.							
quip/Tooling											,			
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Material 🏖 🛭 Setup							}							
			1 1											
Other	4													
Process	_								•		•			
Supplier			1 1	•					•					
Training			1.			1						t.		
Unapproved		1	<u></u>			ALII T	CATE	CORV		<u> </u>				
Landin	g Gear			,	General	AULI	CATE	3011				·		
[Bending				Bend	П	irain		· · · · [Ovalized	Г	Pressure/Forced		
ŀ	Centre No	ot Conce	ntric to (o/s	BOM/Route	\mathbf{H}	lardwa	re	<u> </u>	Over/Unde	er tolerance	Temperature/Cure		
F	Cracks			''	Broken/Damaged	$\boldsymbol{\vdash}$		on Incomplete		Part Incorr	 	Weld		
ļ	Crushed/	Crimped			Burrs	⊢		ions Incomplete/	Unclear	Part Lost/N	/lissing	Wrong Stock Pulled		
-	Cuffs			.	Contamination	-		nance		Part Move	d	- .		
Ī	Heat Trea	at			Countersink	\square	/lislabe	led		Positioned	Wrong			
	Inspection	n Strip ir	Tube		Cut Too Short	\square	/lisread		. [Power Loss	/Surge	Other		
÷~	Ripples in	Bend			Drill Holes	Offset								
Ī	Torque W	n [Drawing	 0	ot of C	Calibration								

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4003-13 REF JCA-M47-2-22 OPY 100271 MLJ 13-04-24 Ø0.375 NOM 0.035 REF D4003-13 FORWARD FUEL GUTTER LINE

NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Φ0.375 X 0.035 WALL THICKNESS PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF DART SPEC M6061T6T0.375W.035

2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D4003 MFG. APPR. SHEET 9 OF 9 TITLE APPROVED SCALE DE APPR. LINE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT OF PRIVATE AND COMPRESSION, MICH. SEPPLED ON THE FROM THE TOTAL VIEW OF ANY PRIVATE OF THE PRIVATE OF T DATE 10.02.05